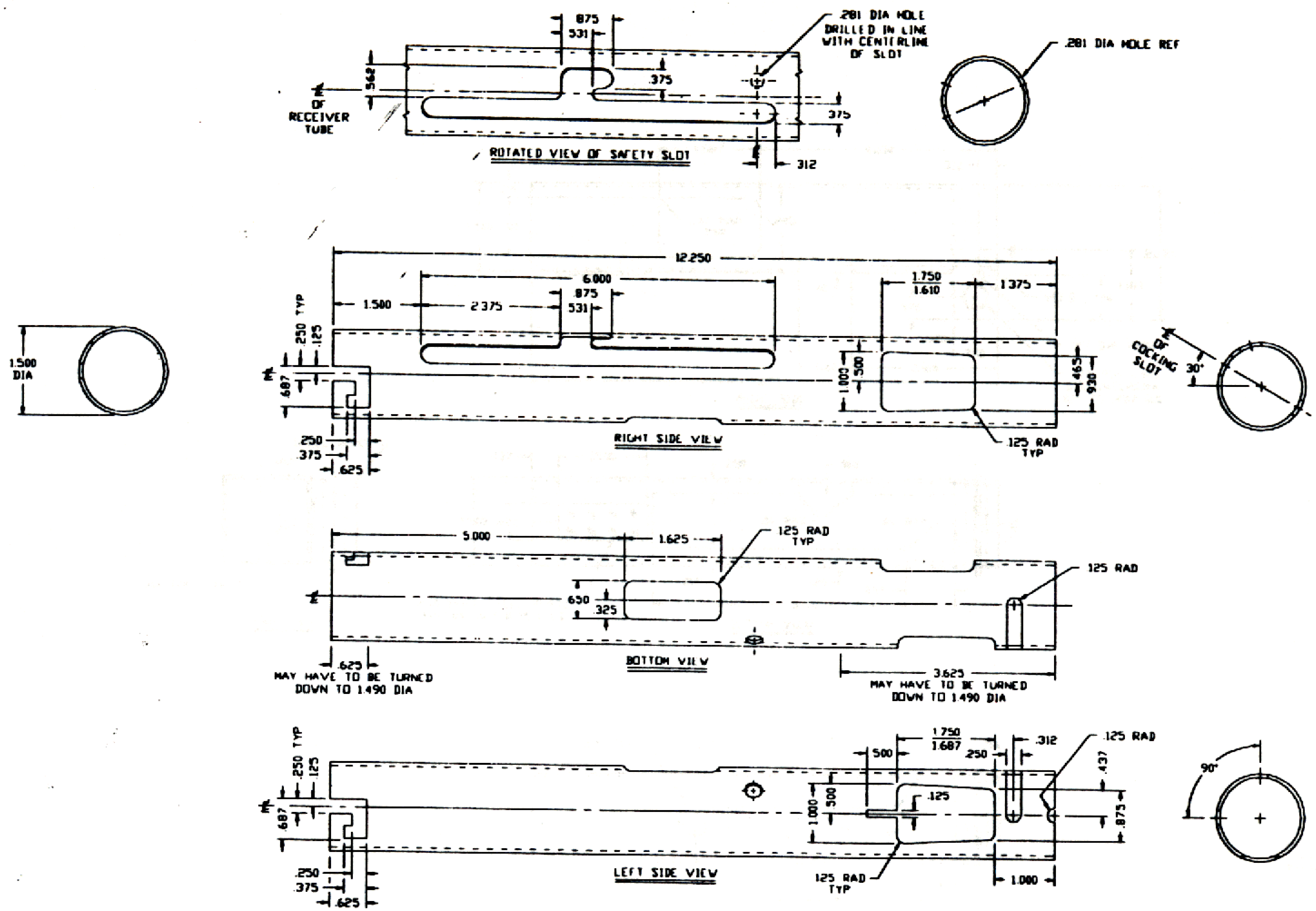
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NOTES:

1 MATERIAL- MILD STEEL SEAMLESS , DRAWN OVER MANDREL 1500 O.D X .049, .055, 062 WALL.

2 FINISH- PAINT BLACK.

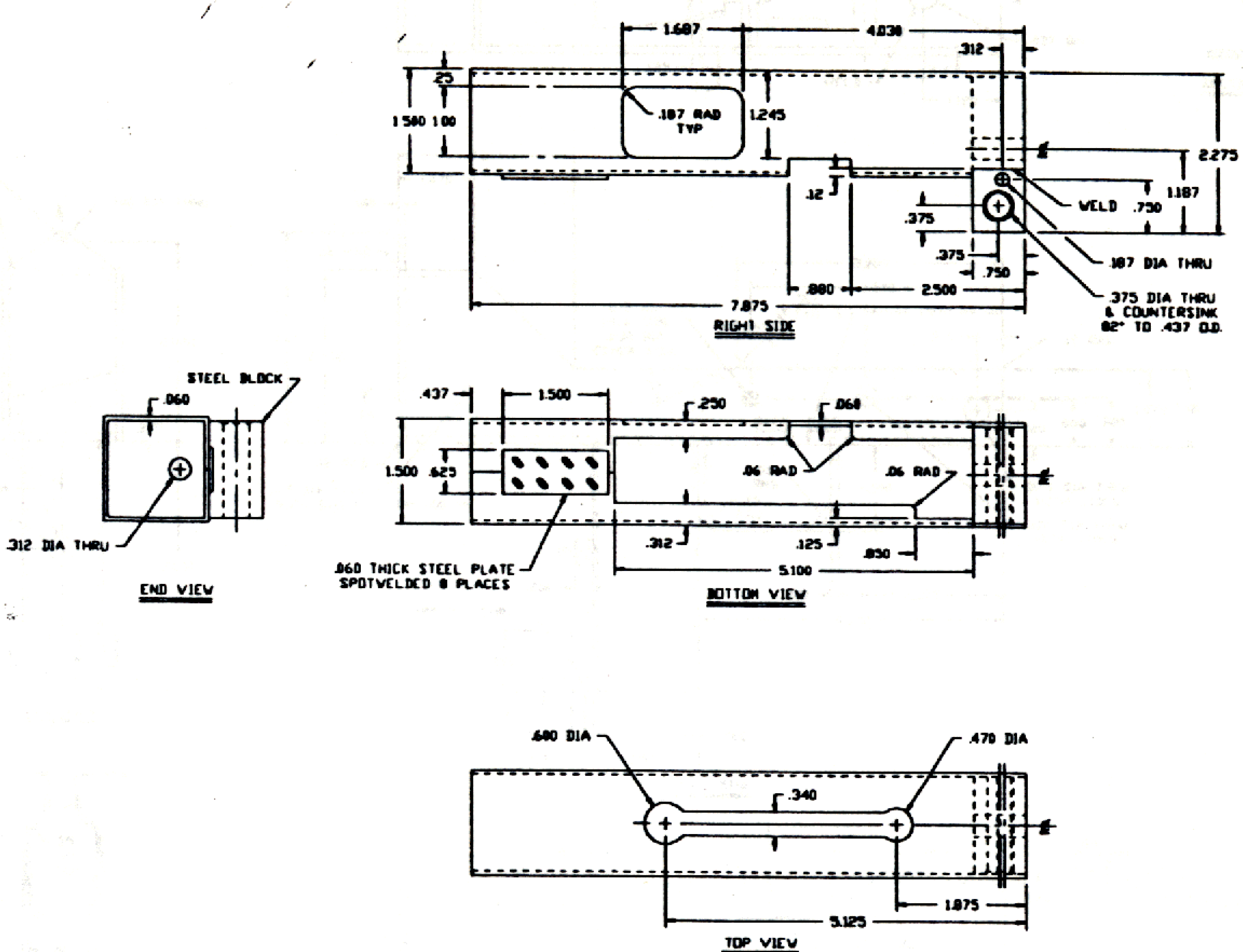
3 SHORTCUT TO CONSTRUCTION CAN BE ACCOMPLISHED BY CUTTING TUBE FLUSH TO REAR SIGHT RING AND FLUSH TO BARREL BUSHING IF THIS METHOD IS USED, A REDUCTION IN LENGHT MUST ALSO BE MADE

4 .625 AND 3.625 DIMENSIONS MAY NEED TO BE TURNED DOWN TO 1.490 DIA TO FIT MAGAZINE HOUSING AND REAR SIGHT RING.

RESTRICTED MATERIAL


CONFIDENTIAL

SCALE: FULL	MATERIAL: SEE NOTE 1	CHK	TOLERANCES
DWN	FINISH: SEE NOTE 2	DATE	
TITLE: STEN MK-V RECEIVER		REV.	NO.



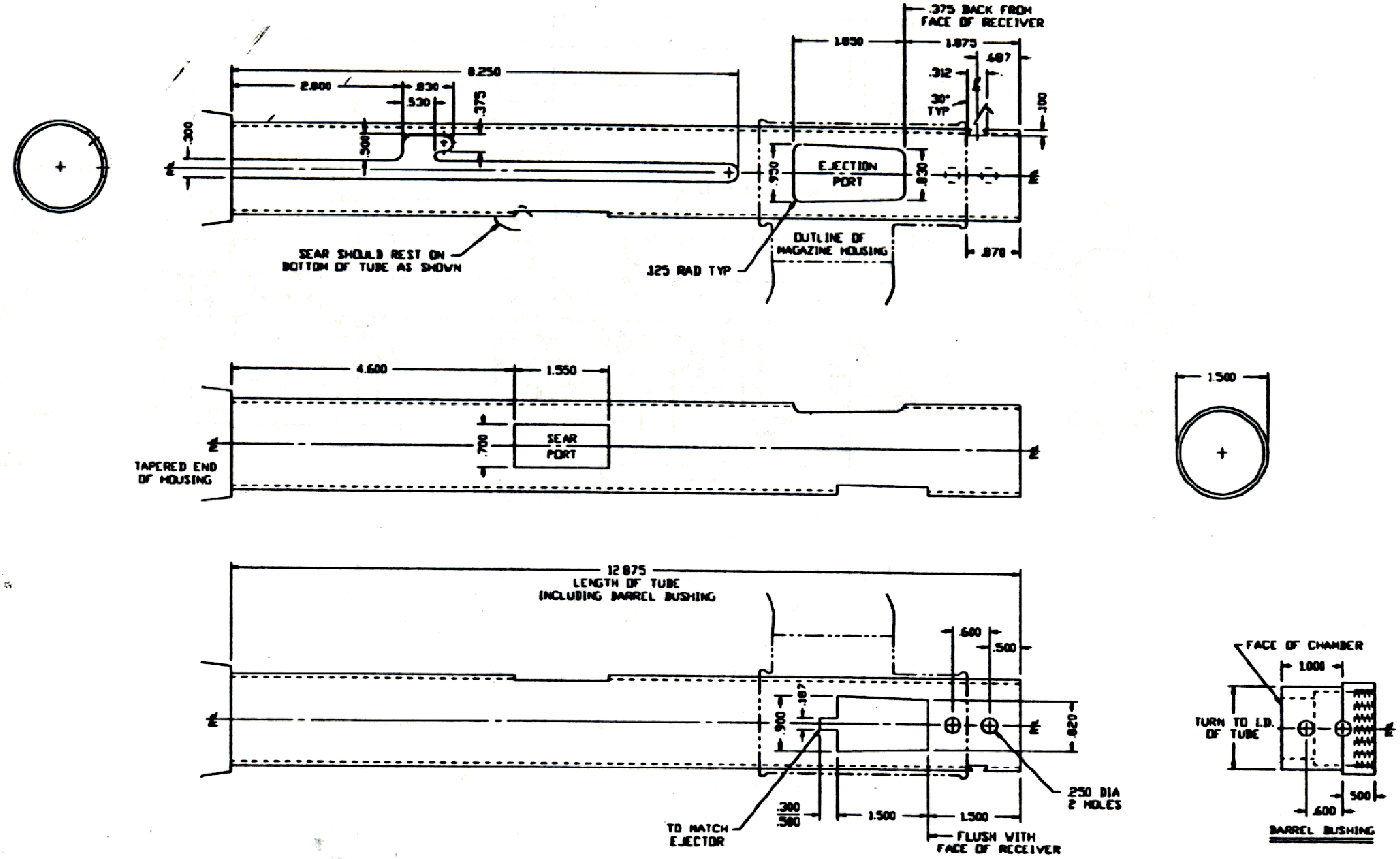
NOTES-
1. MATERIAL- .060 THICK X 1.500 SQUARE TUBE - 1018 STEEL
2. FINISH- DARK PHOSPHATE - PARKERIZE

SCALE: FULL	MATERIAL: SEE NOTE 1	
DWN:	FINISH: SEE NOTE 2	
TITLE: MAC-10 UPPER RECEIVER		REV.



CONFIDENTIAL

RESTRICTED MATERIAL



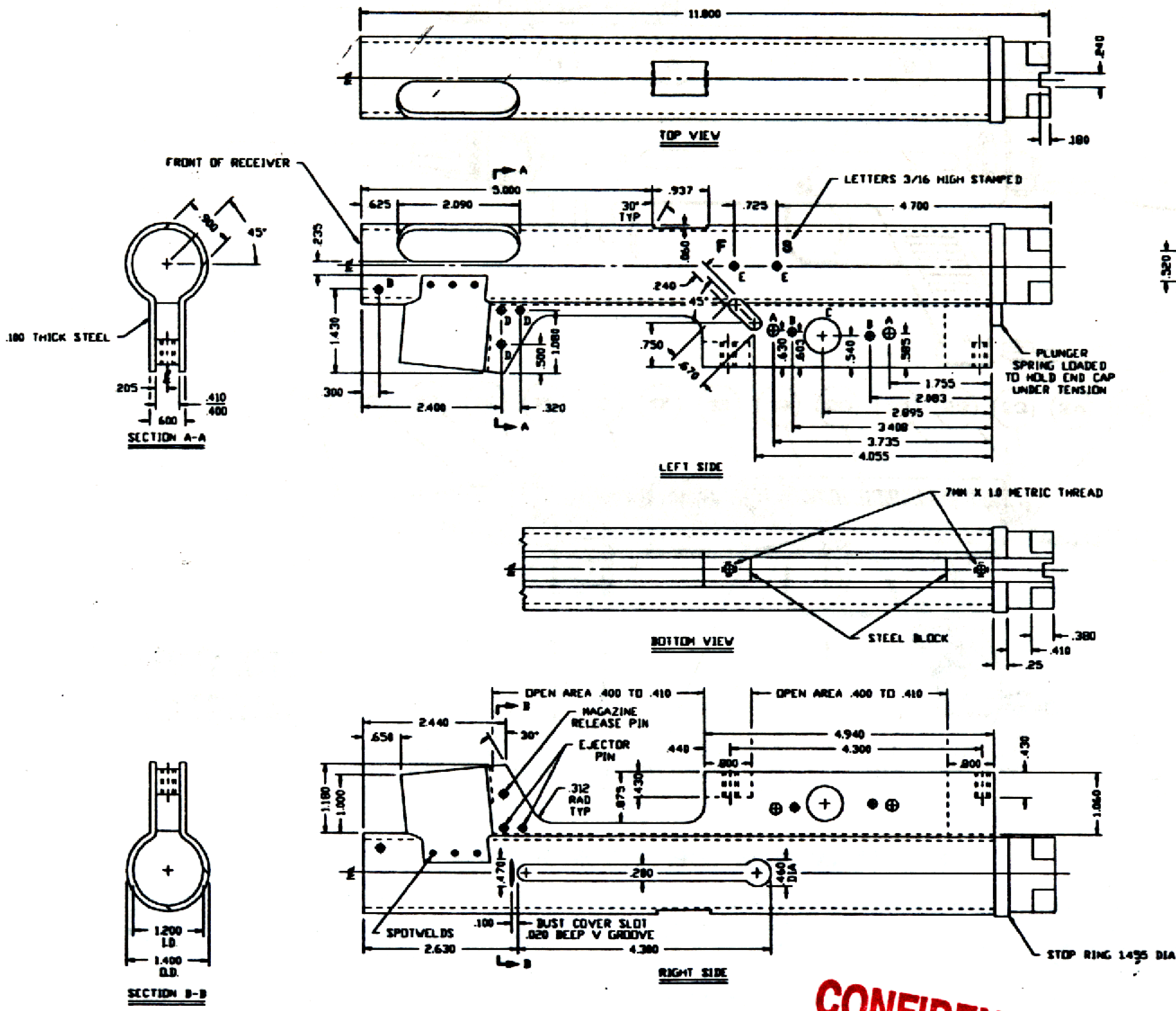
NOTES:

1. MATERIAL- 1.500 O.D X .065 WALL D.O.M. STEEL TUBE
2. FINISH- PARKERIZE AND PAINT FLAT BLACK

RESTRICTED MATERIAL

CONFIDENTIAL

SCALE: FULL	MATERIAL: SEE NOTE 1	CKD.	TOLERANCES
DWN.	FINISH: SEE NOTE 2	DATE	
TITLE: AUSTEN MK I RECEIVER		REV.	NO.



DRILL CHART

HOLE	DESCRIPTION	QTY
A	.201 DIA THRU	2
B	.145 DIA THRU	3
C	.610 DIA THRU	1
D	.135 DIA THRU	3
E	.145 DIA X .030 DEEP	2

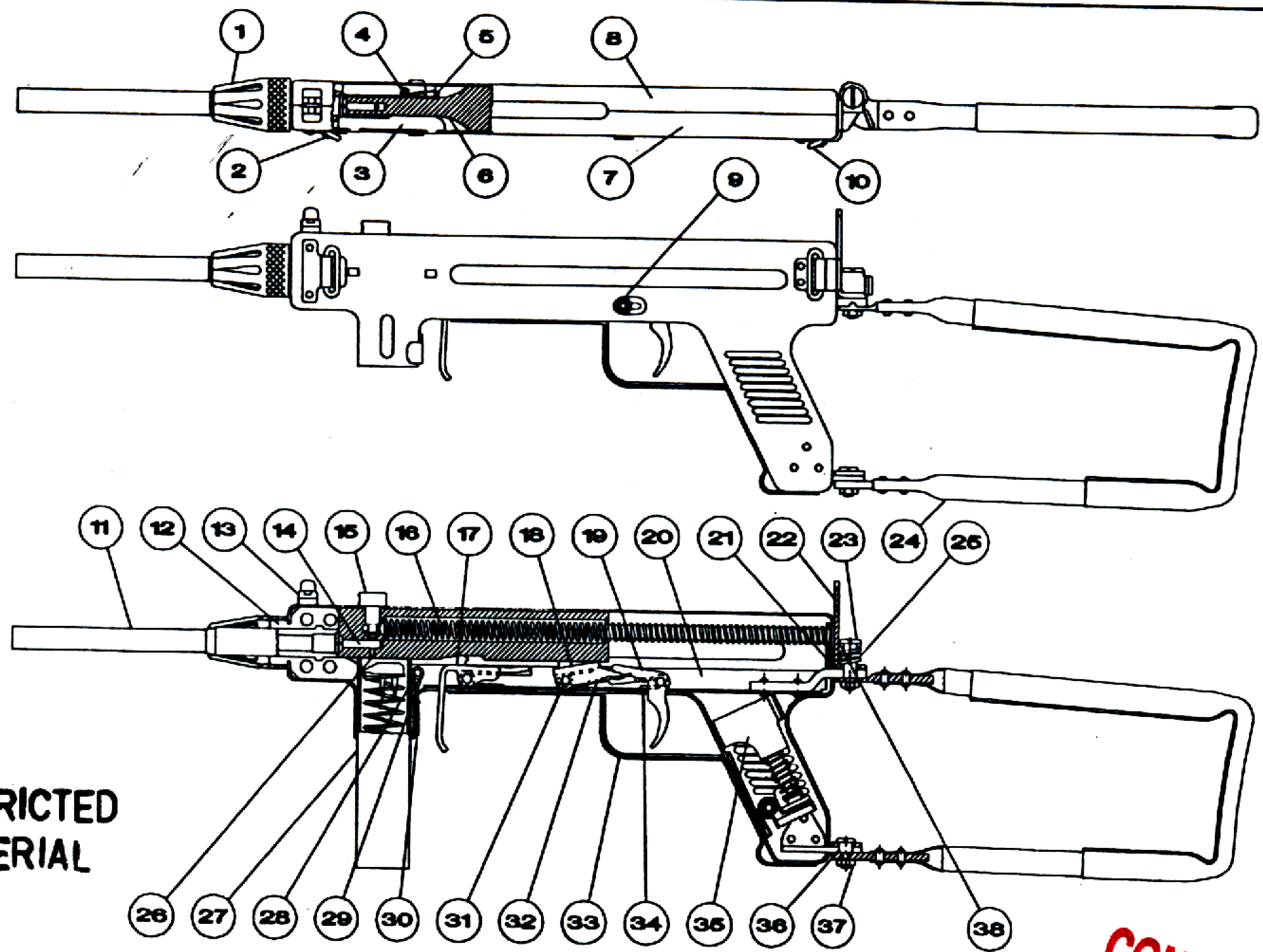
NOTES:

1. MATERIAL- 1.500 O.D. X 1.187 I.D. STEEL D.O.M. TUBE
2. FINISH- BLUE
3. FRONT OF RECEIVER TUBE INTERNALLY THREADED TO MATCH BARREL THREAD.
4. IF REBUILDING RECEIVER USING PARTS KIT DO THE FOLLOWING
   - A. TRIM TUBING AWAY FROM TRIGGER HOUSING.
   - B. TURN TUBE (NEW) TO 1.400 OUTSIDE DIAMETER.
   - C. BORE TUBE (NEW) TO 1.200 INSIDE DIAMETER. THEN SLOT BOTTOM OF TUBE TO .410 WIDTH.
   - D. FIT TUBE TO EXISTING REMAINS.
   - E. TACK WELD IN PLACE.
   - F. FIT END CAP RETAINING END TO TUBE AND TACK WELD.
   - G. CHECK FOR ALIGNMENT WITH TRIGGER HOUSING AND BUTT STOCK BEFORE FINAL WELD.
   - H. FINISH WELD AND FINAL MACHINE.

RESTRICTED MATERIAL

CONFIDENTIAL

SCALE: FULL	MATERIAL: SEE NOTE 1	CKD	TOLERANCES
DWN	FINISH: SEE NOTE 2	DATE	ANGLES ± .5°
TITLE: BERETTA 38A AND 38/44 RECEIVER		REV.	NO




RESTRICTED MATERIAL

CONFIDENTIAL

MADSEN MODEL 1950 SUBMACHINE GUN

1 BARREL BEARING NUT
2 SLING SWIVEL
3 EJECTOR
4 EXTRACTOR PIN
5 EXTRACTOR
6 BREECHBLOCK
7 FRAME HALF (LEFT)
8 FRAME HALF (RIGHT)
9 SAFETY CATCH
10 SLING SWIVEL
11 BARREL
12 BARREL BEARING
13 FRONT SIGHT
14 FIRING PIN
15 COCKING HANDLE
16 RETURN SPRING
17 BREECH BLOCK RETAINER
18 TRIGGER ROD
19 TRIGGER
20 TRIGGER PLATE
21 RETURN SPRING GUIDE (COMPLETE)
22 REAR SIGHT PLATE
23 SHOULDER PIECE BOLT (UPPER)
24 SHOULDER PIECE
25 SHOULDER PIECE SPRING
26 FIRING PIN RIVET
27 MAGAZINE
28 MAGAZINE CATCH PIN
29 MAGAZINE CATCH SPRING
30 MAGAZINE CATCH
31 TRIGGER ROD PIN
32 TRIGGER ROD SPRING
33 TRIGGER GUARD
34 TRIGGER SPRING
35 MAGAZINE LOADING APPARATUS
36 SHOULDER PIECE BOLT (LOWER)
37 SHOULDER PIECE BOLT NUT
38 SHOULDER PIECE LOCK

SCALE:	MATERIAL:		TOLERANCES
		DATE	
TITLE: MADSEN MODEL 1950 SUBMACHINE GUN		REV.	ANGLES ±


PARTING LINE
RIGHT SIDE
LEFT SIDE
SECTION A-A
.125 DIA
2 HOLES AT "A"
.250 DIA
6 HOLES AT "C"
DRILL IN LINE
THRU BOTH SIDES
.156 DIA
2 HOLES AT "B"
DRILL IN LINE
THRU BOTH SIDES
VIEW B-B
.187 DIA
2 HOLES AT "D"
BOTTOM VIEW
.270 DIA
LEFT SIDE
TRIGGER PLATE
MATERIAL: .075 THICK STEEL
.03 RAD MAX
TAB
EJECTOR
TAB ON EJECTOR SHOULD
PROTRUDE ENOUGH TO BE
PEANED OVER
NOTES:
1. MATERIAL: .06 THICK STEEL UNLESS OTHERWISE SPECIFIED
2. FINISH: PAKERIZE - PAINT BLACK
SCALE: FULL
MATERIAL: SEE NOTE 1
FINISH: SEE NOTE 2
TITLE: MADSEN
MODEL 50 RECEIVER
CONFIDENTIAL
RESTRICTED
MATERIAL

LIST OF PARTS SUPPLIERS

wholesale guns and ammo, inc.
232 blydenburgh rd.
central islip, NY 11722

www.gunsnammo.com

international military antiques , inc.
p.o.box 256 millington ,NJ 07946

www.ima-usa.com

inter ordnance of america l.p.
3305 westwood industrial drive
monroe , NC 28110

www.inter-ordnance.com

sarco , inc.
323 union st. p.o. box 98
stirling , NJ 07980

jeffs shooters supply
p.o.box 1054 trussville , AL 35173

rpb industries
p.o.box 367 avondale est. GA 30002